

BLUE

SPRIT-1

23

Date: Wednesday, 5/16/2007 8:13:35 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	: 32378 - 1	Part Number	: D29322
Estimate Number	: 10832	Drawing Number	: D2932 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 5/16/2007 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 6/6/2007
Previous Run	: 31250	Qty:	16
Written By	: <u>07.05.16</u>	Unit:	Each
Checked & Approved By	: <u>07.05.16</u>		
Comment	Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D5101003	7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)
7075-T7351 2X6.25X7.875
Issue material from stock: 7075-T7351 (QQ-A-250/12)
Cut Size 2.0 x 6.25 X 7.88
Grain Along Long 7.88 Length
Batch No: 1331387

ml 07/06/25

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
5-Deburr

ml 07/06/25

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

ml 07/06/25

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

ml 07/06/25

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Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 32378

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.06.26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.L.

07/06/27

2X

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

R/O: 4000 C/L 7/07/05 (3)

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

7/07/11 (1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/11 (1) SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/07/12 (1)

Job Completion



7/07/12

DART AEROSPACE LTD		Work Order: 32373
Description: 206 Saddle, Outboard, Right side		Part Number: D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.125	0.126	0.126	0.126		
B	0.100	0.140		0.127	0.127	0.126	0.126		
C	0.100	0.140		0.120	0.119	0.120	0.120		
D	0.210	0.230		0.225	0.222	0.223	0.223		
E	1.245	1.255		1.249	1.256	1.258	1.250		
F	1.245	1.255		1.249	1.258	1.258	1.256		
G	2.495	2.505		2.500	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.575	1.577		
J	2.495	2.505		2.499	2.500	2.499	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		0.119	0.117	0.117	0.117		
O	0.540	0.560		0.548	0.549	0.550	0.548		
P	0.490	0.510		0.499	0.504	0.502	0.504		
Q	3.715	3.725		3.717	3.717	3.716	3.717		
R	2.470	2.510		2.494	2.494	2.494	2.492		
S	0.240	0.270		0.255	0.254	0.257	0.253		
T	0.100	0.180		0.140	0.138	0.138	0.138		
U	1.625	1.635		1.628	1.629	1.629	1.628		
V	1.362	1.372		1.368	1.367	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.133	1.134	1.134		
Y	1.565	1.585		1.574	1.573	1.573	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Measured by: <i>gmk</i>	Audited by: <i>SA</i>
Date: 07/06/25	Date: 01.06.26

Rev	Date	Change	Revised by	Approved
A		New Issue		
02.12.12		Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
03.21		Revised per drawing revision C	KJ/JLM	